

77861

December-22-11 8:53:20 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** ~~400~~ 50 ***4***

Cust Item ID:

Required Date: 05/01/2012 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-559	rev L

100	0.00
-----	------

100

DOCUMENT CONTROL

DC	Memo	0.00
----	------	------

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

160	Pick Kit	0.00
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160

Pick Kit

Packaging	Memo	0.00
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Packaging

170	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

170

QC4- 100% Inspect kits for completeness

QC	Memo	0.00
----	------	------

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77861

77861

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December-22-11 8:53:20 AM

Item ID: D206-559-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 22/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: SATP

[Signature] 12/2/21 75

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/2/21 *[Signature]*

ME 12-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-22-11 8:53:24 AM

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Work Order ID: 77861

77861

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:J04.02.17Blank size changedKJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	480.0000	12				
AN4-17A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST359				480					
				118628				80					
				118983				300					
				119798				100					
AN4-20A		Purchased	No			160	Each	530.0000	12				
AN4-20A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				50					
				116419				50					
				ST359				480					
				117514				180					
				118983				100					
				119127				200					
AN960JD416	NAS1149D0463J	Purchased	No			160	Each	0.0000	24				
AN960.ID416									**				
Washer													

4860
 m112314. 8x.
 m120187. 44x.
 8x.
 4860
 SP.
 m164016. 16x.
 23x
 21x
 96 120
 m119075/20x
 SP 12-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December-22-11 8:53:24 AM

Work Order ID: 77861

77861

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No

160 f

580.1642 2.5 10

D2182B

Rubber Cushion

**

Location

Loc Qty

Loc Code

ST410

580.16417

66063

53.94817

73932

526.216

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

1.0000 12

D2274

Radius Block

**

Location

Loc Qty

Loc Code

ST010

1

73389

1

D2432 Manufactured No

160 Each

0.0000 2

D2432

206 (24") Bearpaw

D2438 Manufactured No

160 Each

127.0000 6

D2438

Clamp

**

Location

Loc Qty

Loc Code

ST456

127

69737

84

73400

43

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December-22-11 8:53:24 AM

Work Order ID: 77861

77861

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2529 Manufactured No

160

Each

226.0000

12

D2529

Washer

**

48 LEO
B79485 LEOX SP E

Location

Loc Qty

Loc Code

ST016

226

71161

6

76086

220

D2732 Manufactured No

160

f

357.0700

2.5

10

D2732

Rubber Extrusion

**

SP E

Location

Loc Qty

Loc Code

ST410

357.07

70987

357.07

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

12.5 x

MS21042L4 Purchased No

160

Each

8,975.000

12

MS21042L4

Nut

**

48 LEO
SP 12-02-27 E

Location

Loc Qty

Loc Code

ST300

8975

117441

51

117601

342

118451

133

119017

3449

119075

5000

LEOX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP